



Dart Aerospace Ltd.
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Canada

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D3340-13
Job Sheet 212111



Part No: D3340-13

Job Qty: 2 pcs

Part Name: Skidtube Protector



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/7/20

Job Tracking No:

Due Date: 8/24/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP: A 05.11.10 Preliminary issue AP/EC IPP Rev:B Now on Waterjet 06-10-06 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2 pcs		8/22/20	0.17	0.37	Waterjet - Flow		ac 20/08/10
110	QC 2	2 pcs		8/22/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		ac 20/08/10
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Plex 8/7/20 10:18 AM Dart.lajeunesse.marie

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

Plex 8/7/20 10:12 AM Dart.lajeunesse.marie

					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
150	Powdercoat - 3 Grey Sand - B4B	2 pcs	8/24/20	0.00 0.09	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
					Powdercoat - 5 - B4B	
					Powdercoat - 6 - B4B	
					Powdercoat - 7 - B4B	
					Powdercoat - 8 - B4B	
					Powdercoat - 9 - B4B	
					Powdercoat - 10 - B4B	
160	QC 3	2 pcs	8/24/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
					QC 3 - 87	
170	Packaging 3-1 - Stock - B4B	2 pcs	8/24/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	

AUG 13 2020

20-08-17

DAS 34 9-89

DAS 82 9-89

AUG 17 2020

DAS 28 9-89

AUG 17 2020

				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	2	8/24/20	0.00 0.00	QC 21 - SA - 21	DAS 21 9-ss
	pcs			QC 21 - SA - 70	AUG 17 2020
				QC 21 - SA - 9	
				QC 21 - SA - 77	

Part Op 100 - 1-Cut as per Dwg D3340 Dwg Rev: B Prog Rev: B 2-Deburr if necessary
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - QC8- Inspect parts - second check
 130 - (Bend/Assemble as per dwg), Deburr if necessary Form on brake as per Dwg D3340 using Jigs DT 8326 and DT8261
 140 - QC5- Inspect part completeness to step on W/O
 150 - (Grey Sandtex(Ref 4.3.5.6) per QSI005 4.3), START TIME: 7:45 M138889 OVEN TEMPERATURE: 320°
 FINISH TIME: 8:15
 160 - QC3- Inspect Part Finish
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1010S20GA	1010/1025 Sheet	2.5200 sf (1.26 ea)	100-Waterjet - Flow - 1	<u>5032206</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M1010S20GA	3	73	0

Part Specifications

Specifications could not be found.

Plex 8/7/20 10:12 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 212111
Description: Aft Skidtube Protector		Part Number: D3340-13
Inspection Dwg: D3340	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

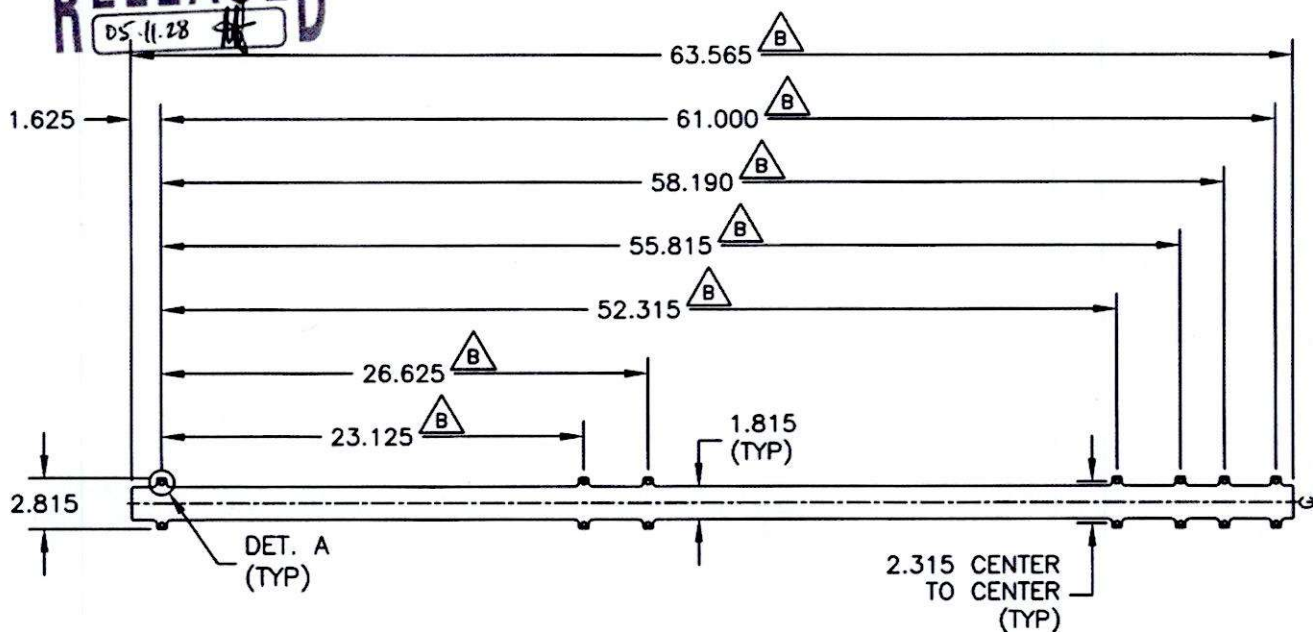
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	.248	1		Viper-04	
0.300	+/-0.010	.301	1		" "	
0.50	+/-0.030	.50	1		Tap	
0.250	+/-0.010	.251	1		Viper-04	
2.315	+/-0.010	2.310	1		" "	
2.815	+/-0.010	2.816	1		" "	
1.625	+/-0.010	1.628	1		" "	
23.125	+/-0.010	23.125	1		Tap	
26.625	+/-0.010	26.625	1		"	
52.315	+/-0.010	52.315	1		"	
55.815	+/-0.010	55.815	1		"	
58.190	+/-0.010	58.190	1		"	
61.000	+/-0.010	61.000	1		"	
63.565	+/-0.010	63.565	1		"	
0.040	+/-0.010	.035	1		Viper-04	

Measured by: <i>or</i>	Audited by: DAS 81	Preliminary Approval:
Date: 20/08/10	Date: AUG 12 2020	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	<i>[Signature]</i>

DART

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3340	REV. B SHEET 6 OF 11
DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10

RELEASED
05.11.28 *[Signature]***D3340-13F FLAT PATTERN****D3340-13 AFT SKIDTUBE PROTECTOR****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 212111 *MS*

08 07

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

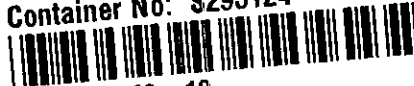
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					



Container No: S293124



Part: D3340-13

Job No: 212111

Serial No/Batch: S293124

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 08/10/20